



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3204-5

Job Sheet 193508



Part No: D3204-5

Job Qty: 12 pcs

Part Name: Arm



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/16/19

Job Tracking No:

Due Date: 4/26/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 pcs	4/26/19	4/26/19	0.00	0.01	Bandsaw - 1		signed 19/4/21
110	HAAS 4 Axis - B4B	12 pcs	4/26/19	4/26/19	0.27	3.92	HAAS - 1 - B4B		signed 19/4/21
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	12 pcs	4/26/19	4/26/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		1/4/22 19/4/22
140	Packaging 3-1 - Stock - B4B	12 pcs	4/26/19	4/26/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		

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				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	WA001-3 ST APR 22 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	12 pcs	4/26/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS 21 APR 22 2019
				QC 21 - SA - 53	

Part Op 100 - (Bandsaw) Cut blank: 1.25" x 0.375" x 3.370" long Bar (+0.030/-0.000)
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1- Machine as per Folio FA344 and Dwg D3204 Identify as D3204-5
 130 - QC8- Inspect parts - second check)
 140 - (Identify as per dwg & Stock Location: _____) LOCATION : WA001-3
 150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.375X01.250	6061-T6 Bar .375 X 1.25	3.3600 ft (.28 ea)	100-Bandsaw - 1	5157422

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.375X01.250	3	22	0

MAT
used
5812

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm	0.375Inches $\pm$ 0.010	0.385 0.365	Radius	.375
2	Arm	0.750Inches $\pm$ 0.010	0.760 0.740		.750
3	Arm	0.500Inches $\pm$ 0.030	0.530 0.470	Radius	.500
4	Arm	0.500Inches $\pm$ 0.010	0.510 0.490	Radius	.500
5	Arm	0.760Inches + 0.005 - 0.000	0.765 0.760	Diameter	.760
6	Arm	0.080Inches $\pm$ 0.010	0.090 0.070		.078
7	Arm	2.373Inches $\pm$ 0.005	2.378 2.368		2.373
8	Arm	0.375Inches + 0.005 - 0.000	0.380 0.375	Diameter	.375
9	Arm	0.250Inches $\pm$ 0.010	0.260 0.240		.247
10	Arm	0.060Inches $\pm$ 0.030	0.090 0.030	Radius	.060
11	Arm	0.200Inches $\pm$ 0.010	0.210 0.190		.202

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					